Qty:

Each

Tuesday, 30/09/2008 8:54:24 AM

User:

Julie Lecocq

## **Process Sheet**

**Drawing Name** 

**Part Number** 

Material

**Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: SPACER

: D30661

: N/A

: B

- D3066 REV.B

: 15/10/2008

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 42345

**Estimate Number** 

: 10383

P.O. Number

: 30/09/2008 This Issue Prsht Rev.

: NC

First Issue **Previous Run** 

Written By

: //

: 41446

Type

S.O. No. :

Checked & Approved By

Comment

Incorporated D3066-1 IPP KJ/RF Now M6061-T6 06-06-23 JLM Est Rev:B

: SMALL /MED FAB

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6061-T6 .080 Sheet

FLOW WATER JET

1.0

M6061T6S080



图 8-10-20

0.0992 sf(s)/Unit Total: Comment: Qty.:

Material: 6061-T6 0.080" thick

(M6061T6S.080)

Batch: 168433

9.9225 sf(s)

2.0

WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3066

Dwg Rev:\_\_\

Prog Rev:\_

2-Deburr if necessary

B8~10~2

3.0 QC2



INSPECT PARTS AS THEY COME OFF MACHINE

B 8-10-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

HAND FINISHING

HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1



08-10-2

XLO

Dart Aeı	rospace	e Ltd							
W/O:			V	ORK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		PAR #:	Fault Ca	tegory:	NCR: Yes	No DC	λA:	Date: _	
	R	esolution:	Disposit	ion:	QA: N/C	Closed:		Date: _	
NCR:		1	WORK OR	DER NON-CONFORMA	NCE (NC	R)			
		Description of NC		Corrective Action Section	n B	Verif	ication	Approval	Approval
DATE	STEP Description of NC Section A		Initial Action Description Chief Eng Chief Eng		Sign Dat	& Sec	tion C	Chief Eng	QC Inspector
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NOTE: Date & initial all entries

Tuesday, 30/09/2008 8:54:25 AM Date: ∙User: Julie Lecocq **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Part Number: D30661 Job Number: 42345 Job Number: Description: Seq. #: **Machine Or Operation:** INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3 Comment: INSPECT CHEMICAL CONVERSION COAT PACKAGING RESOURCE #1 PACKAGING 1 7.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ QC21 8.0

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

Dart Aerospa	ce L	.td
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	1	<del>-</del> -								
W/O:			M	ORK ORDER CHANG	GES					
DATE STEP		PROCEDURE CHANGE			В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		iv. *								
										·
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: `	Yes N	o <b>DQ</b>	<b>A</b> :	_ Date: _	
Resolution: _		esolution:	Disposition:			QA: N/C Closed: Date:				
NCR:		,	WORK OR	DER NON-CONFORM	ANCE (i	VCR)				
DATE	STEP	Description of NC Section A	Corrective Action Section Initial Action Description		tion B	on B Sign &		ation	Approval Chief Eng	Approval QC Inspector
		Section A	Chief Eng	Chief Eng		Date	Secil		Office Ling	1 QO IIIspector
						· · · · · · · · · · · · · · · · · · ·		******		
		· .								

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42345
Description: Spacer	Part Number:	D3066-1
Inspection Dwg: D3066 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype								
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments		
Ø0.128	+0.005 -0.000	1133	×					
0.708	+/-0.010	1702	x					
0.354	+/0.010	,352	*					
0.354	+/0.010	.351	8					
2.250 (Pitch)	+/-0.005	3.300	×					
16.450	+/0.010	16,450	Ø					
0.080	+/-0.010	,on	×					
<u> </u>				-				
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Measured by:	Audited by:	Prototype Approval:	N/A
Date: 8-10- 70	Date: Ocio Do	Date:	N/A

Rev	Date	Change		 Revised by	Approved
A	03.09.22	New Issue	P/O D3065-041	KJ/RF	
В	06.06.23	Dwg Rev. changed		 KJ/JLM OK	



DESIGN DRAWN BY DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B **APPROVED** D3066 SHEET 1 OF 1 DATE TITLE SCALE 06.05.29 **SPACER** 1:3 Α 02.09.11 **NEW ISSUE** В 06.05.29 ADD 6061-T6 MATERIAL

0.000

0.354

RELEASED Cle . Cle · Ze

2.600 4.850 7.100 9.350  $\emptyset$  0.128 (#30) (TYP 8 PLACES) 11.600 13.850 16.096 16.450 0.708 R0.354 (TYP) 0.354

**D3066-1 SPACER** 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" T計版KOPY (REF DART SPEC M6061T6S.080) RETURN TO

ENGINEERING

WITHOUT NOTICE

WORK ORDER

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICKNONTROLLED COPY (REF DART SPEC. M5052H32S.080) SUBJECT TO AMENDMENT

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 6) ALL DIMENSIONS ARE IN INCHES

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